

Work Order ID 146632

Thursday, May 19, 2016 2:59:41 PM

146632

Page 1

Item ID: D206-648-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Ground Handling Wheel Modification

Start Date: 5/13/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/19/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MJS Date: MAY 25 2016

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D206-648	Rev B

JUL 06 2016

DAS
6
9-89DAS
21
9-89
1607062

100 Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D206-648-013
CHG002

JUL 21 2016

110 Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

JUL 19 2016

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.06

Quality Control

JUL 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

Work Order ID 146632***146632***

Page 2

Thursday, May 19, 2016 2:59:41 PM

Item ID: D206-648-013

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Ground Handling Wheel Modification

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Required Date: 5/19/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-648-013

DAS
27
9-89

JUL 2 1 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.20

Quality Control

DAS
21
9-89

JUL 2 1 2016

DAS
21
9-89

JUL 2 1 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : ☐																	

Picklist Print

Page 1

Thursday, May 19, 2016 2:59:40 PM

Work Order ID: 146632

146632

Parent Item: D206-648-013

D206-648-013

Parent Item Name: Ground Handling Wheel Modification

Start Date: 5/13/2016

Required Date: 5/19/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A05.09.23New issueKJ/JLM
IPP Rev:B 07-12-05 ECN 1080p DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2652		Manufactured	No			110	Each	175.0000	8	16			
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D2652

Bushing

**

X 16 B147559 Pc

Location	Loc Qty	Loc Code
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FG	45	
----	----	--

31985	45	
-------	----	--

ST009	130	
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141609	130	
--------	-----	--

D3414-041		Manufactured	No			110	Each	18.0000	2	4			
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D3414-041

Lug

**

Pc

Location	Loc Qty	Loc Code
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ST531	18	
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136607	16	
--------	----	--

136608	2	
--------	---	--

AN3C37A		Purchased	No			110	Each	322.0000	4	8			
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AN3C37A

BOLT

**

Pc

Location	Loc Qty	Loc Code
----------	---------	----------

OVER002	210	
---------	-----	--

M131856	70	
---------	----	--

M132169	70	
---------	----	--

M132381	70	
---------	----	--

ST347	112	
-------	-----	--

131651	70	
--------	----	--

M128773	0	
---------	---	--

M131367	42	
---------	----	--

DAS
27
9-89

JUL 19 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐		☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
Design ☐	☐	Operator ☐		☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
Doc/Data ☐	☐	Offset/Setup ☐		☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
Equip/Tooling ☐	☐	Supplier ☐		☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
Handling/Pre ☐	☐	Training ☐		☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
Material ☐	☐	Use for Testing ☐		☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
Internal Transport ☐	☐	Poor Information ☐		☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
Tribal Knowledge ☐	☐	Rushing ☐		☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
LOA ☐	☐	Product Improvement ☐		☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
Substation ☐	☐	Process Improvement ☐		☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process ☐		OTHER : _____			
Misidentified ☐	☐	Past Due ☐					

Picklist Print

Thursday, May 19, 2016 2:59:40 PM

Work Order ID: 146632

146632

Parent Item: D206-648-013

D206-648-013

Parent Item Name: Ground Handling Wheel Modification

Start Date: 5/13/2016

Required Date: 5/19/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0363R

Purchased

No

110

Each

674.0000

4

8

NAS1149C0363R

Washer

PZ 

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

301

114742

6

m133077

295

GA

345

~~m133077~~

345

ST266

28

m133077

28

MS21043-3

Purchased

No

110

Each

827.0000

4

8

MS21043-3

Nut

X 8 M134861 R



DAS
27
9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

11

m130673

11

GA

363

m133990

363

ST302

267

m134502

267

ST304

106

m131340

106

JUL 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER :									